

Oct-24

Work Order ID 62305



Friday, September 24, 2010 3:29:19 PM

Page 1

Item ID: D4108-047

Accept



Setup Start



Revision ID:

Item Name: Sill Doubler Assembly

Stop



Start Date: 9/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *MNF*

Date: *10-9-24*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4108	A

100 Pick Kit 0.00



Packaging

Packaging

EJ 10/10/20 ②

110 0.00



Small Fab

Small Fab

EJ 10/10/20 ②

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

2 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionIdentify as per dwg & Stock Location: 129Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 62305



Parent Item: D4108-047



Parent Item Name: Sill Doubler Assembly

Start Date: 9/27/2010

Required Date: 10/4/2010

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD

Start Qty: 2.00

Required Qty: 2.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

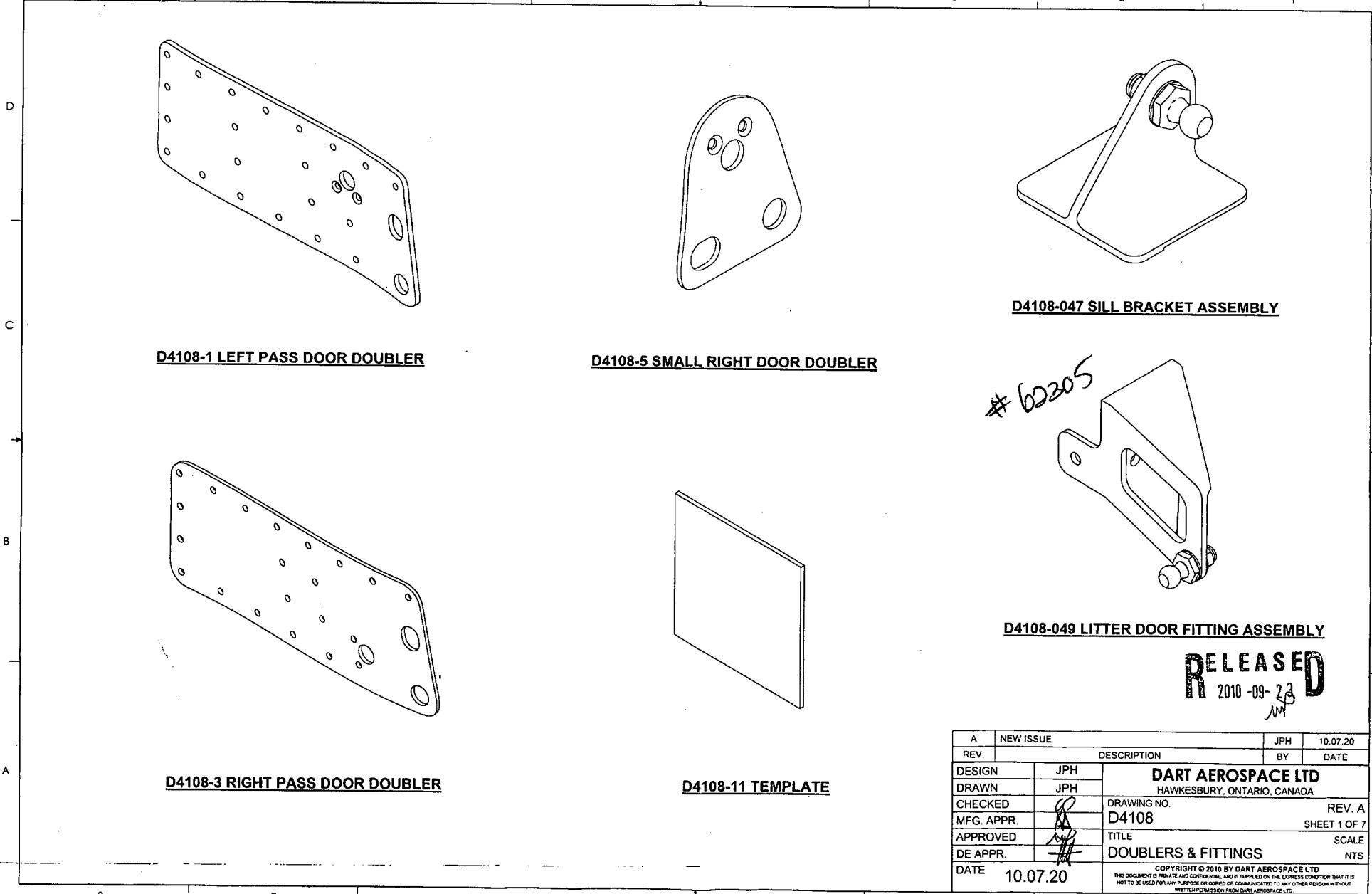
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

A	NEW ISSUE		JPH	10.07.20
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	QF	DRAWING NO.		REV. A
MFG. APPR.	X	D4108		SHEET 1 OF 7
APPROVED	MF	TITLE		SCALE
DE APPR.		DOUBLERS & FITTINGS		NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

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NOTE: Date & initial all entries

8

7

6

5

4

3

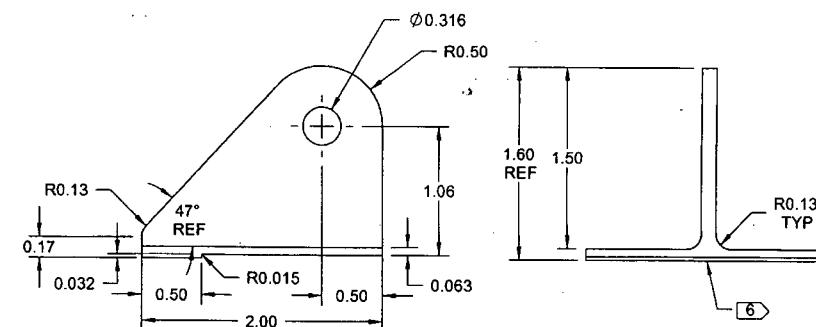
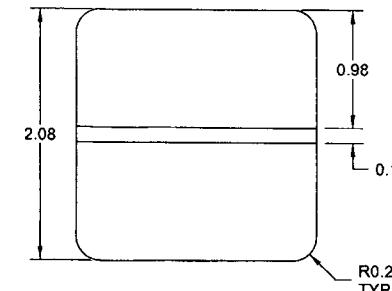
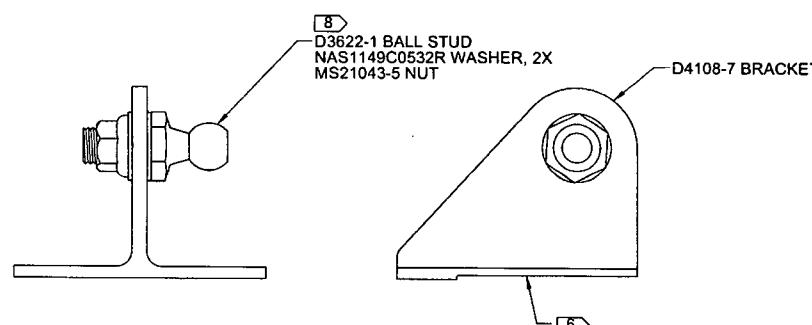
2

1

Qty	Part Number	Description
1	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER

D

D



D4108-7 BRACKET

RELEASED
R 2010-09-23
JPH

NOTES:

- 1) MATERIAL -7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4108-X & B/N PER QSI 044 6.1
- 7) WEIGHT -047: 0.20 lbs
- 8) TORQUE TO 5-10 INCH POUND.

8

7

6

5

4

3

2

1

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
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